Work Order I Tuesday, October 07	ID 125281 7, 2014 10:40:12 AM		*125	281*						Page 1	l
Item ID: D35 Revision ID: Item Name: Brad	557-1 Cket		Accept	*N900	040	100)* s	Setup Star	1.71	S1* S2*	
	06/14 Start Qty: 2.00	*2*		Cust Item I	D:						
Required Date: 10/0	06/14 Req'd Qty: 2.00	*2*		Customer:							
Reference:						_	T.	tun Stai	rt J.B.		
Approvals: Pr	ocess Plan: MU3	Date: 14-10-0	🖔 Tooling:	Da	ate:		•		~! <i>\</i>	R1*	
QC	C:	Date:	_ SPC (Y/N): _	Da	ate:			Sto	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3557	Rev A									210	
100	FLOW WATER JET		0.00				2	0		DAS 23 9-89	4-11-05
Waterjet	Memo	•	0.00								
FLOW CNC Waterjet	1-Cut as pe	r Dwg D3557 Dwg Rev:	_A Prog Rev: <i>A</i>	_							
pole1 175	****Ensure	e Grain Direction is Correct	*****2-Deburr if necessary								
110	QC2- Inspect parts off r	nachine FAI/FAIB	0.00				Ş			DAS 23 9-89 \	4-11-05
110 QC Quality Control	Memo		0.00					_ 0_	-		(1105
120	QC8- Inspect parts - sec	cond check	0.00				(3)			DAS 38	
120 QC Quality Control	Memo		0.00				<u>(2)</u>			9 -89 0 VOV	5 2014

Quality Control

DQA:	QA: Date:						_							***	DART
			0 - 1 -			WORK ORDER NON	-C(ONFO	RMANCE / L	JPDATE				- ,	AEROSPACE
QA Closed:			Date:								W	ork Order u	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					_	Rework]		Skid-tube	Crosstube			Water Jet	٦ E	Engineering
Part N	١٥.					Scrap	i		Machining	Small Fab		Pro	d. Eng. Coor.	7	Quality
						Use-as-is		Thern	noforming	Finishing	Г	-	re/Packaging		Other
NCR N	No					Suspected Unapproved			Large Fab	Composite]	Supplier		
Root					Descr	ription of work order update		l Initial	A	ction		Sign &		Τ	<u>.</u>
Cause	D	ate	Step	Qty		or non-conformance	1	nief Eng		cription		Date	Verification		QC Inspector
Design				,											
Doc/Data															
Equip/Tooling															
Handling/Pre		1													
Material															
Operator		1													
Offset/Setup															
Process															
Supplier		1													
Training															
Transport															
Unapproved															
							FAI	ULT CAT	EGORY						
Landir	ng Gear					General		1				,	_		
		ding			\vdash	Bend		1	rogram		_	Outside Dim	ensions	Pr€	essure/Forced
	Cen	itre No	t Concen	itric		BOM/Route		Grain				Over/Under	tolerance	Se	t-up
	Cra					Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred) —	Ter	mperature/Cure
			k/Ripple,	/Wave		Burrs	<u> </u>	1	on Incomplete/L	*		Part Lost/Mi	ssing	\W€	
	Cufi					Contamination	_	ı	ions Incomplete/			Part Moved	L	wr	ong Stock Pulled
	_	shing			-	Countersink	-	· ·	ned/off center		_	Positioned W	_	_	
		t Treat				Cut Too Short		Mislabe				Power Loss/	Surge	Otl	ner
•			Strip in	Tube		Drawing		Misread	l						
		rks/Cha				Drill Holes		Off-set							
			quence		-	Finish		l	Calibration						
į	lWay	ve/Twi	st in Tub	e		Fit/Function	1	Out of S	equence						

Work Orde				*125	5281*					·		Page	2
Item ID: Revision ID: Item Name:	D3557-1 Bracket			Accept	*N900	040	100)*	Setup	Start Stop	i A	S1* S2*	
	10/06/14	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust Item I Customer:	D:					1.0	. 12	
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		ate:	- 		Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II 130 *120* Brake NC Brake NC)	Operation Description NC BRAKE Memo Bend as per	Dwg D3557	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code DAS 30 9-89	Accep Qty	t Re Qt		Reject Number	Insp. Stamp	<u></u> 14/11/5
140 *1 4 \n* QC Quality Control		QC5- Inspect part compl Memo	eteness to step on W/O	0.00				(2)	<u> </u>			DAS 38 9-89 NOV	0 6 2014

150

Chemical Conversion Coat per QSI005 4.1

0.00

150 HandFinish

Hand Finishing

Memo

0.00

2 \$ H-11-10

DQA:			Date:									T A A C	
000			Data			WORK ORDER NON	-C(ONFO	RMANCE / L		4 (= 0.1		AEROSPACE
QA Closed:	_		Date:		1						Vork Order u	odate only	<u> </u>
Work Orde	er:					DISPOSITION				AGAINST (PEPARTMENT	/PROCESS	
	-					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite		Supplier	
					_		•			_			
Root					Desci	ription of work order update	ı	nitial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design													
Doc/Data	\Box												
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport		•											
Unapproved							<u> </u>						
	-						FAL	JLT CAT	TEGORY				
Landi						General		1		_	_	_	-
		Bending				Bend	-		rogram	_	Outside Dim	ensions	Pressure/Forced
	\dashv	Centre No	t Concer	ntric		BOM/Route	L	Grain			Over/Under	tolerance	Set-up
	-	Cracks				Broken/Damage/Defect		Hardwa	re	<u> </u>	Part Incorred	ct	Temperature/Cure
	_	Crimp/Kin	k/Ripple	/Wave		Burrs	Ш	Inspecti	on Incomplete/U	Inqualified	Part Lost/Mi	- <u>-</u>	Weld
		Cuffs				Contamination		1	ions Incomplete/	—	Part Moved		Wrong Stock Pulled
	-	Crushing				Countersink	-	_	ned/off center		Positioned V		_
	-	Heat Trea				Cut Too Short	${f H}$	Mislabe		Ĺ	Power Loss/	Surge	Other
	-	nspection		Tube		Drawing		Misread	!				
	-	Marks/Ch				Drill Holes	-	Off-set					
	_	Turning Se				Finish			Calibration				
	<u> </u>	Wave/Twi	ist in Tub	e		Fit/Function		Out of S	equence				

Work Orde				*125	281*							Pag	ўе 3
Revision ID:	D3557-1 Bracket			Accept	*N900	04 0	100)*	Setup	Start Stop		S1*	
	10/06/14 10/06/14	Start Qty: 2.00 Req'd Qty: 2.00	*9* *9*		Cust Item I Customer:	D:						• • • •	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1*	t t
Sequence ID/ Work Center II 160 *160* Powdercoat Powder Coating	D	Operation Description White Gloss(Ref: 4.3.5.1) Memo	308 · 2×11	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATURE:	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	, I	Reject Number	Insp. Stamp	SAC A&
170 *170* QC		QC3- Inspect Part Finisl Memo	1	0.00				(2)	>		- A man Falsa	DAS 38 9-89	

180

Identify as per dwg & Stock Location;

0.00

2AQ 30 88-6 NOV 1 3 2014

NOV 1 3 2014

120 Packaging

Quality Control

Memo

0.00

Packaging

DQA:	QA: Date:							ONEO		100 475			***	DART
QA Closed:			Date:			WORK ORDER NON	1-C	JNFO	RIMANCE / U		/ork Order up	odate only		AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
Part N	- No					Rework Scrap Use-as-is Suspected Unapproved		l .	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
D = -4	- T				Doso	rintian of work and ar undate		lmitical		*:				
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance	1	Initial nief Eng		tion ription	Sign & Date	Verification	,	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved											•			
		· · · · · · · · · · · · · · · · · · ·					FA	ULT CAT	regory					
Landir		ear Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple, it n Strip in latter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/U ions Incomplete/ ned/off center led		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance et ssing /rong	S T V	ressure/Forced et-up emperature/Cure Veld Vrong Stock Pulled Other
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	equence					

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Work Orde				*125	5281*							Page 4
Item ID: Revision ID:	D3557-1 Bracket			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Item Name: Start Date: Required Date: Reference:	10/06/14	C 1	*9*		Cust Item 1 Customer:	D:					"IXI	7
Approvals:	Process QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp
190 *1 Q O*		QC21- Final Inspection Memo	- Work Order Release	0.00						14	<u>////</u>	174)

Quality Control

DQA: Date:						. WORK ORDER NOW		ONICOI		ODATE			*(DART
QA Closed:			Date:			WORK ORDER NON	I-C(JINFO	RIVIAINCE / UI		/ork Order up	odate only		AEROSPACE
Work Orde	∍r:					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS		
Part N	. No					Rework Scrap Use-as-is Suspected Unapproved		i .	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		Initial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	۱	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CAT	regory					
Landir		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch	nk/Ripple t n Strip in latter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Un ions Incomplete/U ned/off center led	· · · · ·	Outside Dim Over/Under Part Incorrec Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing /rong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	_	Turning So Wave/Tw		e		Finish Fit/Function		l	Calibration Sequence					

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Picklist Print

Tuesday, October 07, 2014 10:40:12 AM

Work Order ID: 125281

125281

Parent Item:

D3557-1

D3557-1

Parent Item Name: Bracket

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A

New Issue 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125	ader to the control of the control o	Purchased	No		- · · · · · · · · · · · · · · · · · · ·	100	sf	141.7430	0.0343	1)		DA	
M6061T6	SS 125								**			2 :	

M6061T6S 125

6061-T6 .125 Sheet

Location	Loc Oty	Loc Code	
MAT021	141.743		
m127272	29.2		
m127454	43.703		
m127501	5.1		
m128852	31.74		
m130524	32		130524.

Page 1

DQA: Date:				- WORK ORDER NON	I <i>Ci</i>	ONEO		DDATE			**	[™] DART		
QA Closed:			Date:			WORK ORDER NON	1-C(UNFU	RIVIAINCE / UI		ork Order u	odate only		AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS		
Part f	•					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		Initial	Act	ion	Sign &		\top	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CA1	regory					
Landi		Bending Centre No Cracks Crimp/Kir				General Bend BOM/Route Broken/Damage/Defect Burrs		Grain Hardwa Inspecti	ion incomplete/Un	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi	tolerance t		Pressure/Forced Set-up Temperature/Cure Weld
		Cuffs Crushing Heat Trea Inspection		Tube		Contamination Countersink Cut Too Short Drawing		1		Inclear	Part Moved Positioned W Power Loss/S			Wrong Stock Pulled Other
		Marks/Ch Turning S	atter equence			Drill Holes Finish		Off-set Out of C	Calibration					
		Wave/Tw	מטו ווו זכוי	16	1	Fit/Function	1	JUUL OF S	Sequence					

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DART AEROSPACE LTD	Work Order:	125281
Description: Bracket	Part Number:	D3557-1
Inspection Dwg: D3557 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.172	+0.005/-0.001	0.173	_		V	Jkmoi
Ø0.323	+0.006/-0.001	0,324			V	
2.75	+/-0.030	2.75			V	
1.790	+/-0.010	1.792"	_		V	
0.345	+/-0.010	0.346"			٧	
1.445	+/-0.010	1.445	_		V	
0.375	+/-0.010	0.375			ν	
2.250	+/-0.010	2.250	_		V	
		,				
·		4				
-						
		·				
	1	l .	l	1	I	I

DAS

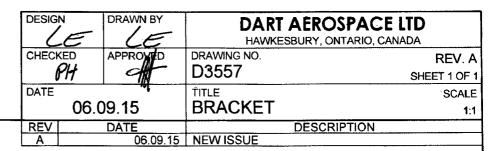
Measured by:

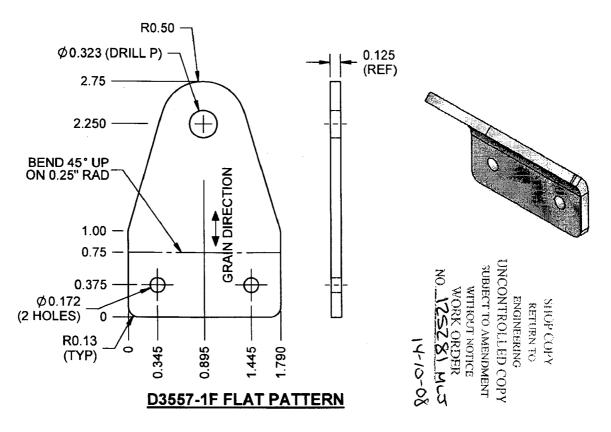
Date: NOV 0 5 2014

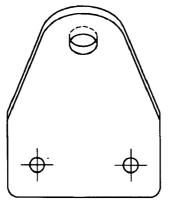
Date: N/A

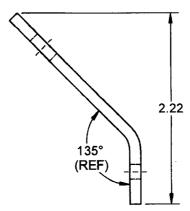
Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM 🛠	E











D3557-1 BRACKET

NOTES

1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11

(REF DART SPEC M6061T6S.125)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
 6) IDENTIFY WITH P/N D3557-1 USING FINE POINT PERMANENT MARKER



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